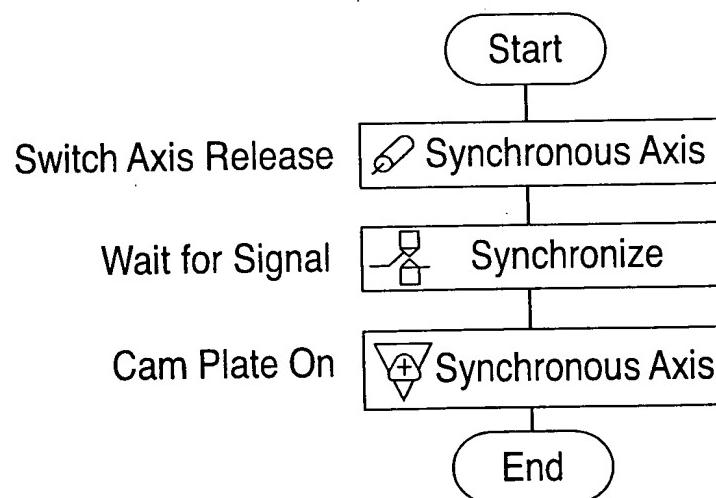


**FIG. 1**



**FIG. 4**

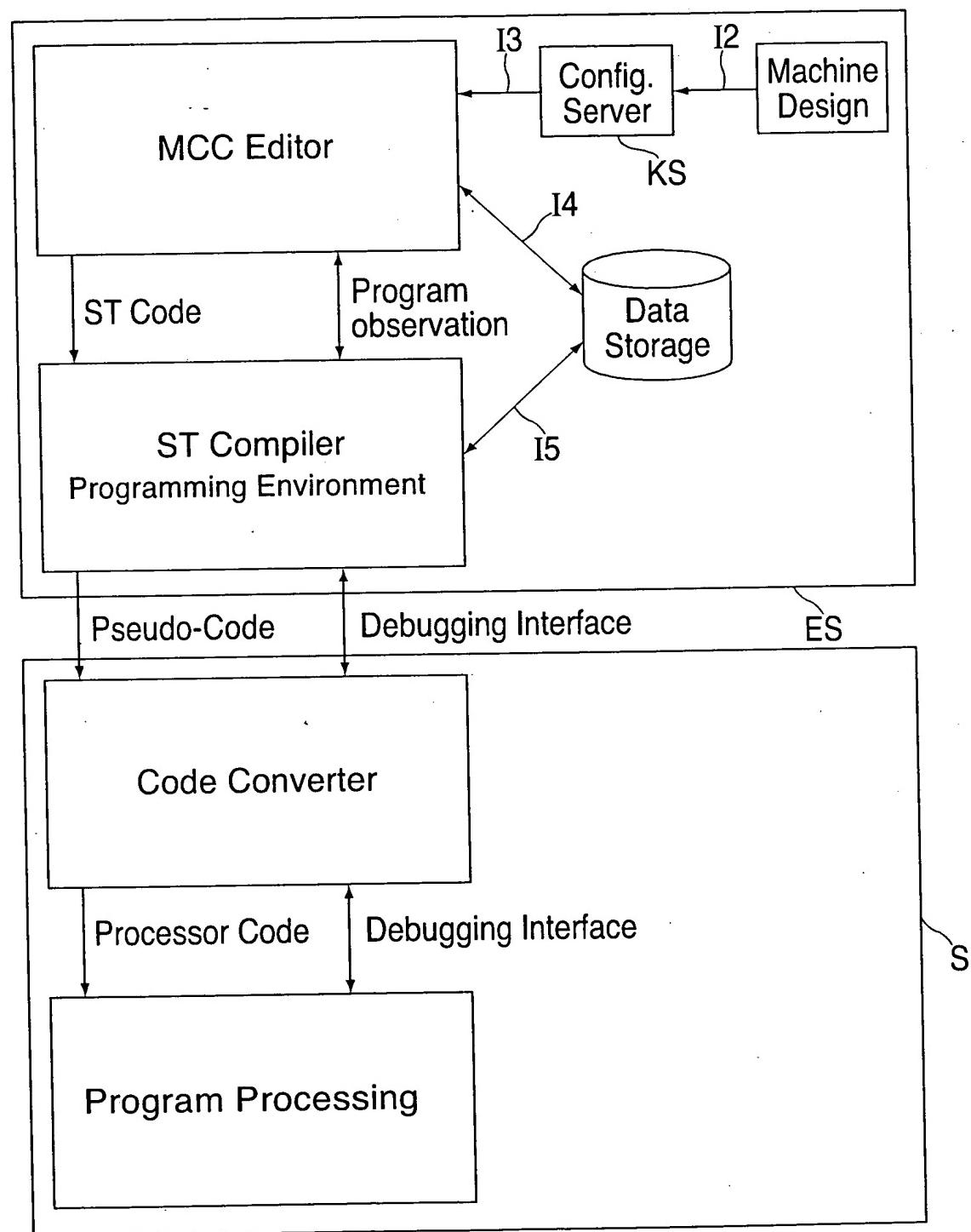
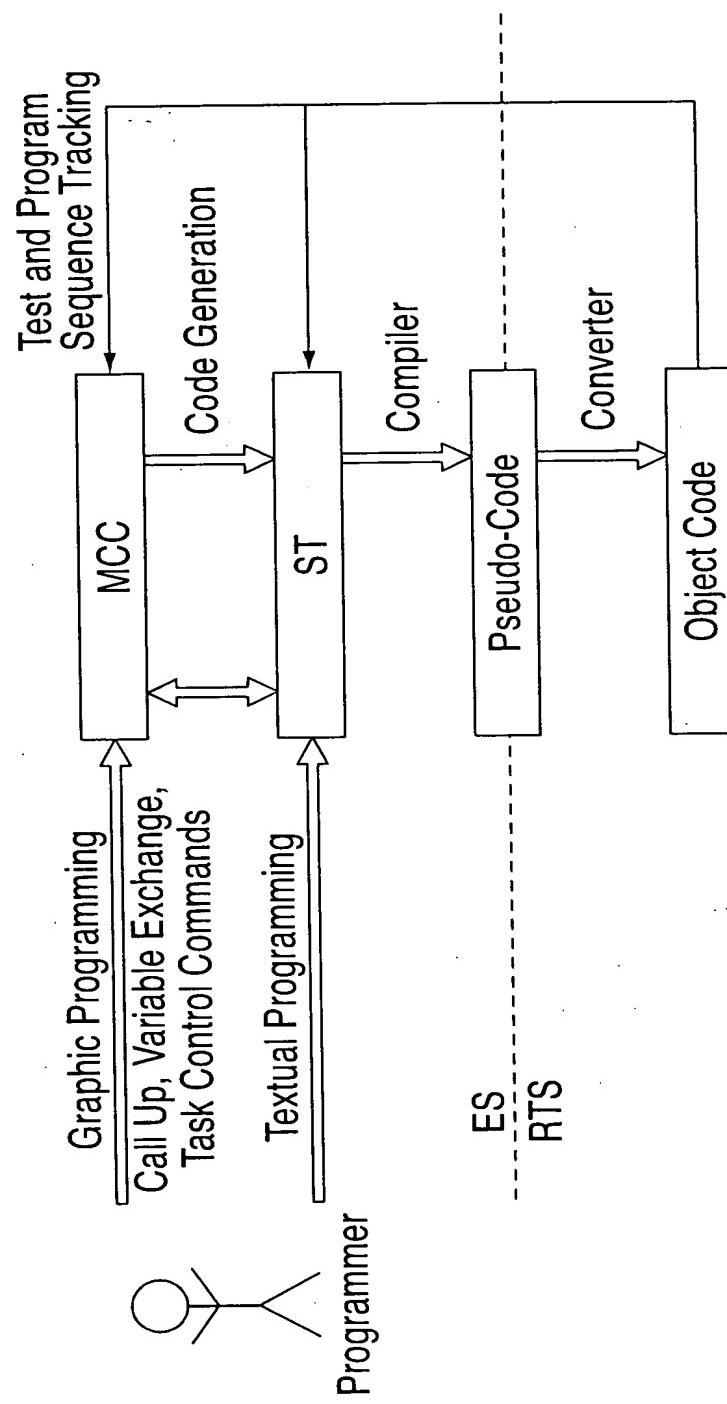


FIG. 2



3

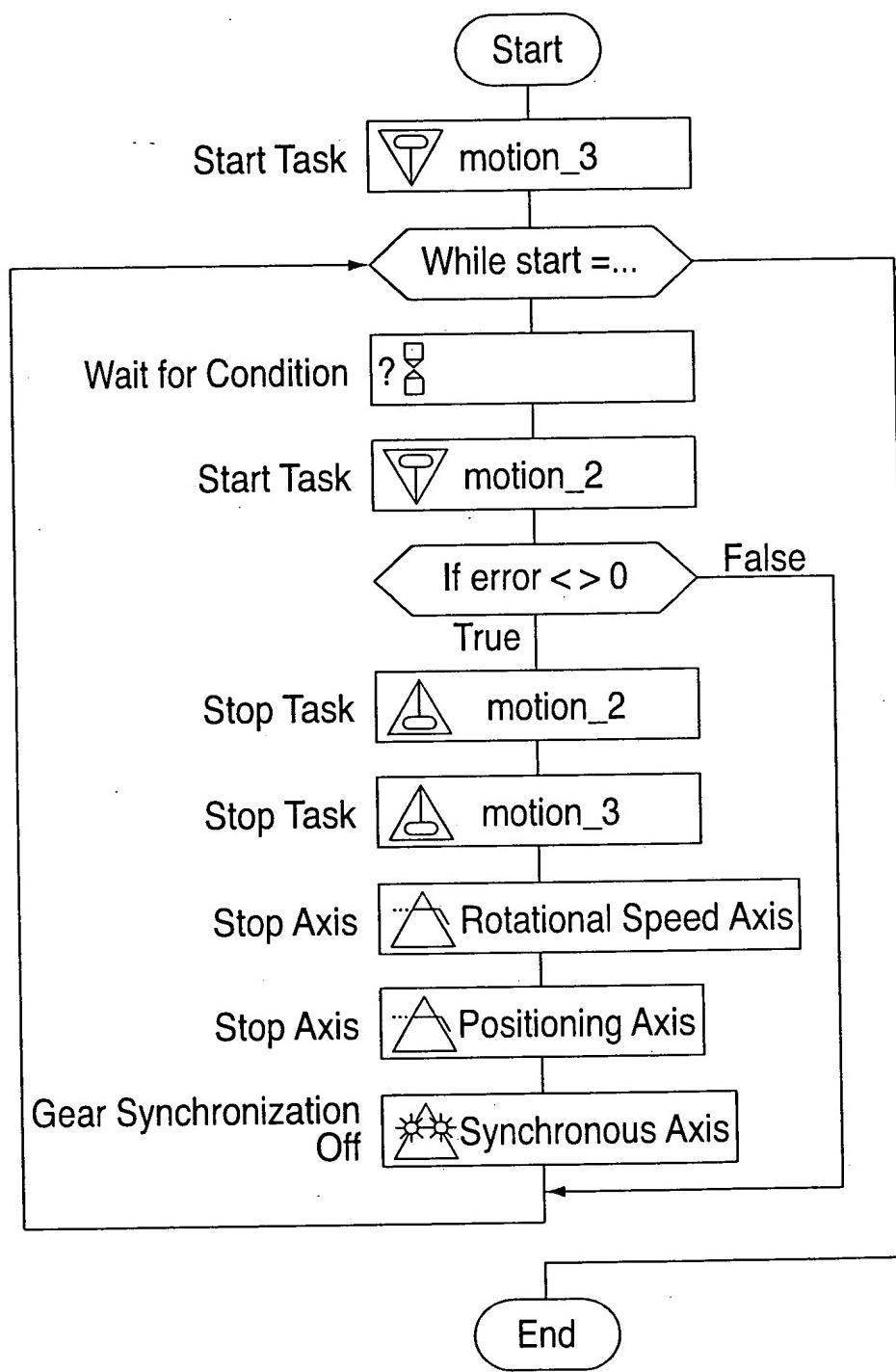
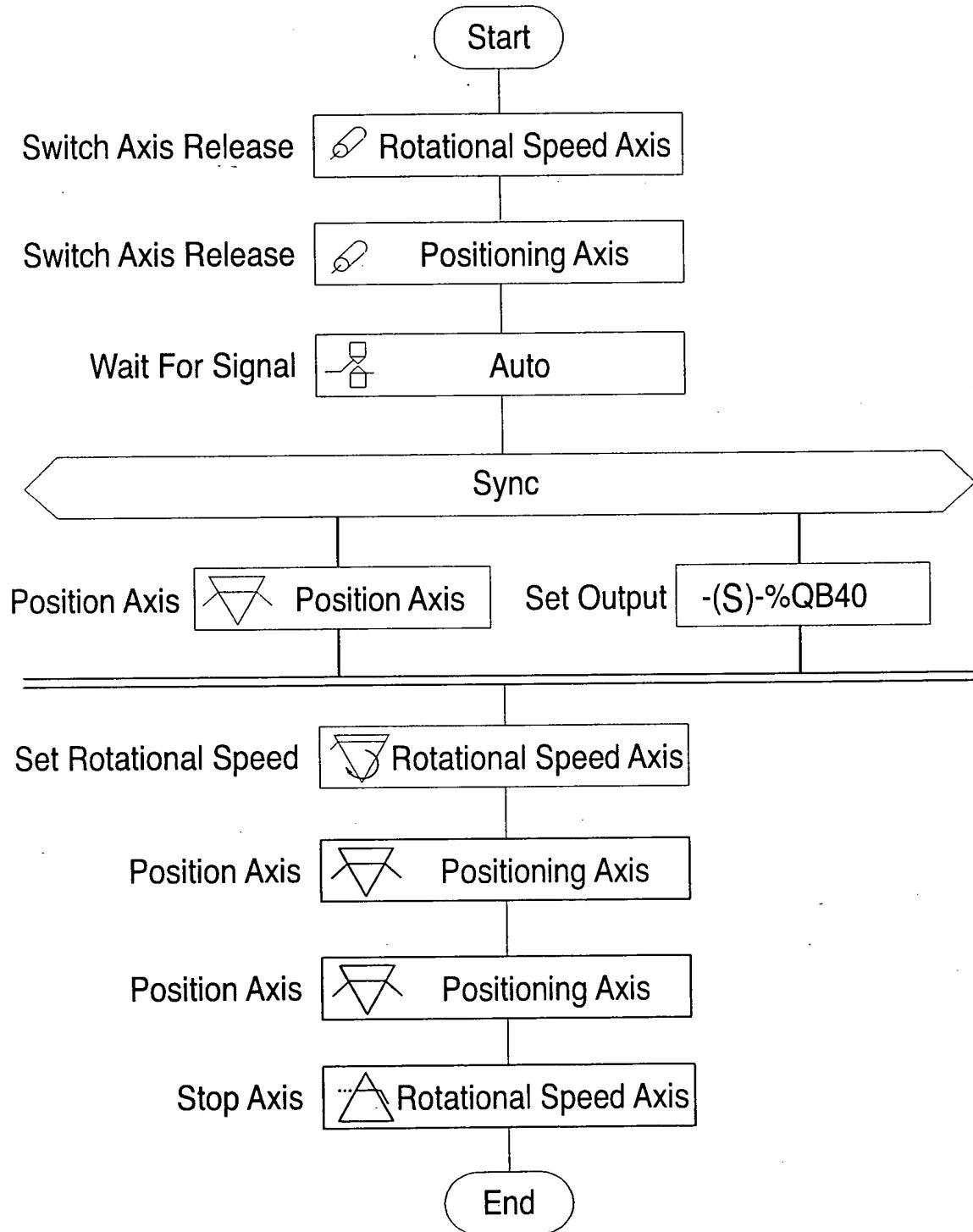
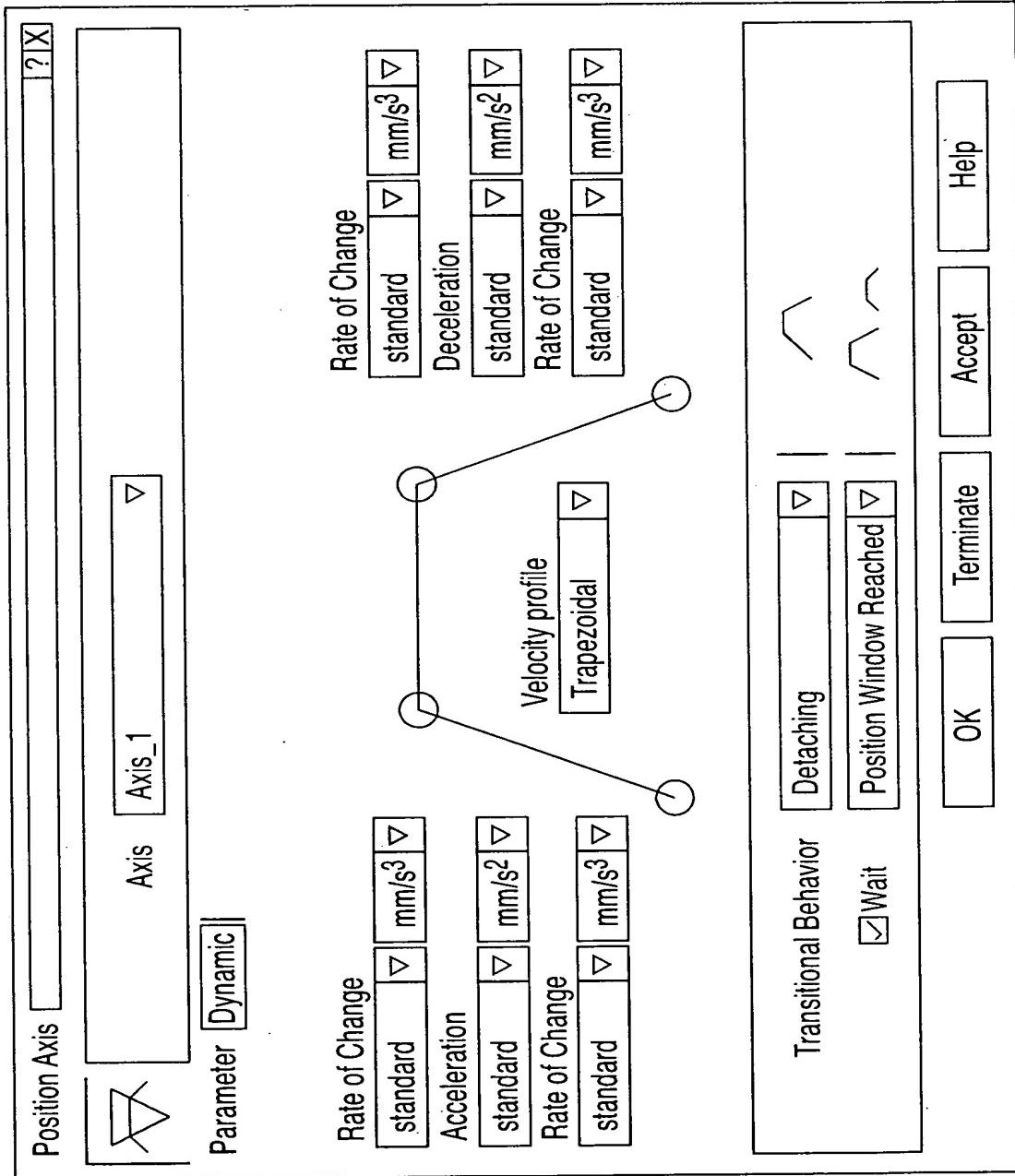


FIG. 5



**FIG. 6**



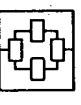
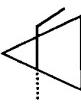
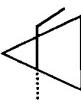
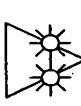
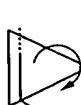
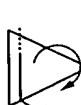
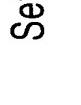
|   |                                |   |  |   |                                     |   |                    |
|---|--------------------------------|---|--|---|-------------------------------------|---|--------------------|
|  | Set rpm                        |  | Activate Gear Synchronization/<br>Gearing On |    | Stop Axis/ Stop Motion Is a Command |  | Macro              |
|    | Set Torque                     |    | Turn Off Synchronization                     |   | Stop Command                        |    | Call Up Subprogram |
|  | Start Axis Position Controlled |  | Activate Cam Plate/ Camming                  |  | Continue Motion                     |  |                    |
|  | Position Axis                  |  | Turn Cam Plate Off                           |  | Parameterize Cam Plate              |  |                    |

FIG. 8